

Work Order ID 81683

81683

Page 1

March-16-12 1:58:42 PM

Item ID: D5955

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle, 205

Start Date: 16/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/03/16*

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D5955

Rev B

100

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine as per folio D5955, Ensure Batch Number is entered
2-Machine Keyway 3-Debur & Tumble

0.00

0.00

110

110

QC

Quality Control

QC1- Inspect dimensions to dimension sheet

Memo

0.00

0.00

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

8 May 12 6:21

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

140

Powdercoat

Memo

0.00

Powder Coating

START TIME:

1h40

OVEN TEMPERATURE:

320°F

FINISH TIME:

2h10

M120 222

8 & (DP) 12/06/25

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

8 & d All n/locks

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 81683***81683***

Page 3

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Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>430</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

8012/6/2612/6/26MF
12-06-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

March-16-12 1:58:47 PM

Page 1

Work Order ID: 81683

81683

Parent Item: D5955

D5955

Parent Item Name: Saddle, 205

Start Date: 16/03/2012

Required Date: 22/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:E Re-Format 05-11-29 JLM
IPP Rev:F ecn826 06.12.06 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-013		Manufactured	No			100	Each	7.0000	1	6			
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D6101-013

**

Saddle Billet

Location

Loc Qty

Loc Code

MAT047

7

46413

7

81925

8

FK 12/06/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	81683
Description: Outer Aft Saddle		Part Number:	D5955
Inspection Dwg: D5955	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.439	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.320	.320	.320	.320		
H	1.522	1.532		1.526	1.526	1.526	1.527		
I	3.048	3.058		3.052	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		.316	.320	.320	.320		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.501	.500	.500	.500		
N	1.865	1.885		1.885	1.883	1.880	1.880		
O	7.990	8.010		8.001	8.001	8.000	8.000		
P	2.240	2.260		2.250	2.251	2.253	2.252		
Q	0.307	0.312		.309	.309	.309	.309		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.500	.502	.500	.500		
T	1.625	1.645		1.627	1.628	1.629	1.630		
U	2.000	2.020		2.000	2.001	2.0018	2.002		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	amx
Date:	12/06/19

Audited by:	SA
Date:	12/6/20

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.08.05	Dimension K revised	KJ/DD	

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DART AEROSPACE LTD		Work Order:	81683
Description: Outer Aft Saddle		Part Number:	D5955
Inspection Dwg: D5955	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	26	27	28	By	Date
A	0.438	0.443		.439	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
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H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		.320	.320	.320	.320		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.500	.501	.499	.499		
N	1.865	1.885		1.880	1.879	1.882	1.880		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.251	2.251	2.253	2.252		
Q	0.307	0.312		.310	.310	.309	.309		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.500	.500	.501	.500		
T	1.625	1.645		1.630	1.629	1.629	1.630		
U	2.000	2.020		2.002	2.001	2.0005	2.002		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

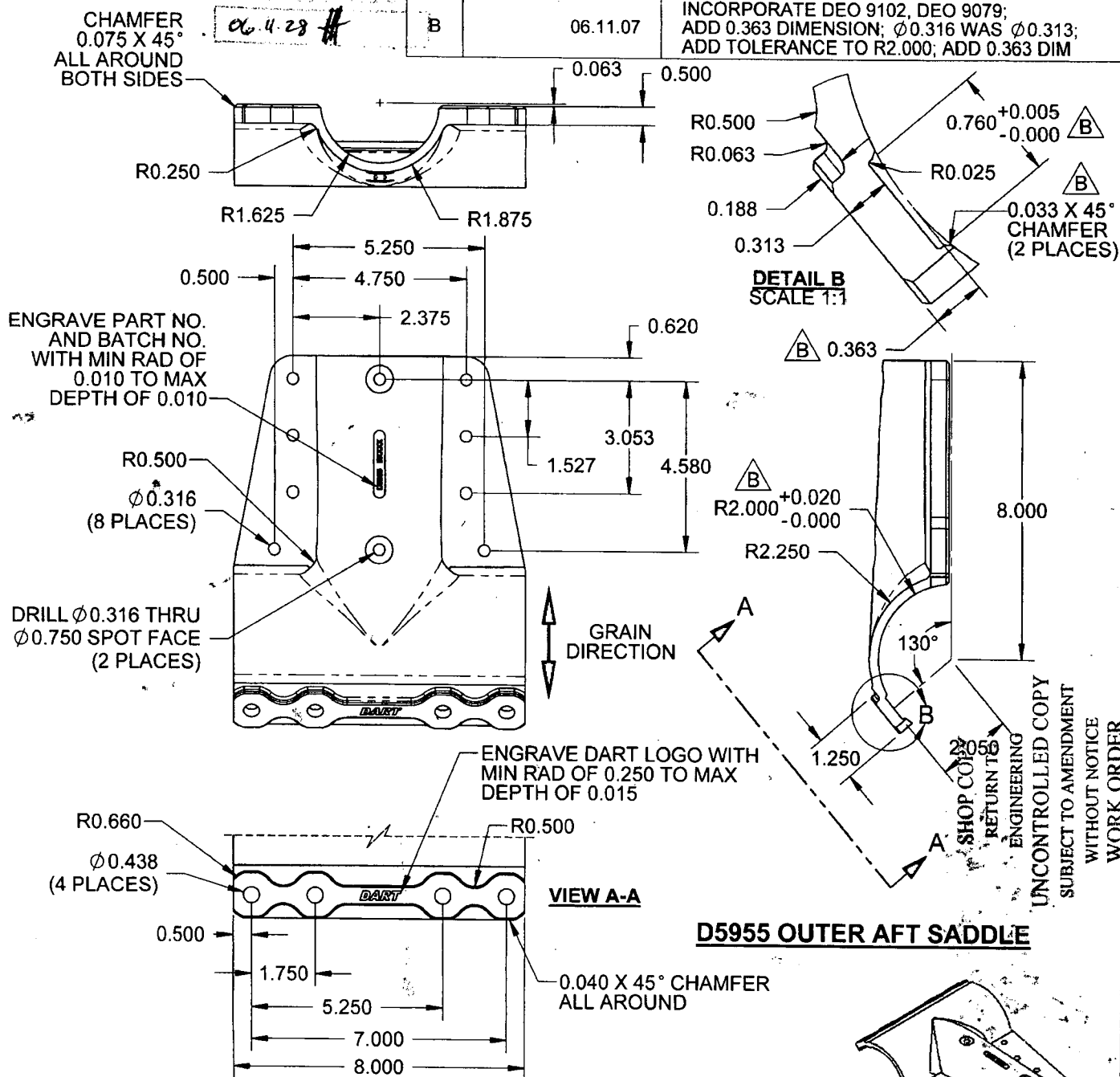
Measured by:	amf
Date:	12/06/19

Audited by:	SJ
Date:	12/06/20

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
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D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.08.05	Dimension K revised	KJ/DD	



DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D5955	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE OUTER AFT SADDLE		SCALE 1:4
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; Ø0.316 WAS Ø0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	

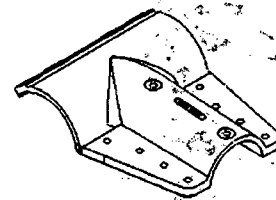


NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12 (MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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ISOMETRIC VIEW
SCALE 1:8

W/O:		WORK ORDER CHANGES					
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